

# Work Order ID 55191

January 11, 2010 12:37:59 PM

Page 1

Item ID: D3947-4

Accept

Setup Start

Revision ID:

Stop

Item Name: Panel, Lower RH Post

Start Date: 1/11/10 Start Qty: 1.00

Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *10-1-11*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3947

A

100

0.00



HAND FINISHING THERMOFORMING

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut Blanks to fit frame size

*PL* 10/01/13 (X)

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-up

2-Pre-heat tool

3-Thermoform as per Dwg. D3947-4and Folio FTA 047 using tool DT9484

Dwg. Rev. *A*

Folio Rev. *B*

*PL* 10/01/13 (X)

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Item Name: Panel, Lower RH Post

Start Date: 1/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control	Visually inspect for proper formation of each part								
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140	HAND FINISHING THERMOFORMING	0.00							
Thermoform	Memo	0.00							
Thermoforming Machine	Trim to Finished Dimensions as per dwg D3946-1								

WL 10/01/13 (X1)

JB 10/01/18 (X1)

JB 10/01/18 (X1)

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Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Lower RH Post

Start Date: 1/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Check dimensions to ensure conformity to drawing tolerances.

OK 10/01/18 (1)

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

→ 5.10.11/18



170



Packaging

Packaging

Identify as per dwg &amp; Stock Location:

0.00

Memo

0.00

HAI Sun

10-1-18 3/12



**Work Order ID 55191**

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Page 4

Item ID: D3947-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel, Lower RH Post

Start Date: 1/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/19

MF 10-1-18

00700JAN.

# Picklist Print

January 11, 2010 12:37:57 PM

Page 1

Work Order ID: 55191



Parent Item: D3947-4



Parent Item Name: Panel, Lower RH Post

Start Date: 1/11/10

Required Date: 1/15/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	749.8927	3.6253			



GE PLASTICS LEXAN SHEET

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	749.8926526	
107574	16.62	
111973	190.526053	
112176	542.7466	

1 @ 6.666

~~3.6253~~ sq ft  
3.444

OK- 10/01/13

(X)

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 5591
<b>Description:</b> Panel, Lower RH		<b>Part Number:</b> D3947-4
<b>Inspection Dwg:</b> D3947	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DT

Date: 10/01/13

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	0.683 "	✓			
1.6	Min	1.6 "	✓			
0.050	Min	0.058 "	✓			
0.065	Min	0.065 "	✓			
22.5	REF	22 "	✓			
10.8	REF	11 "	✓			

Measured by: DT

Date: 10/01/14

Audited by: BB

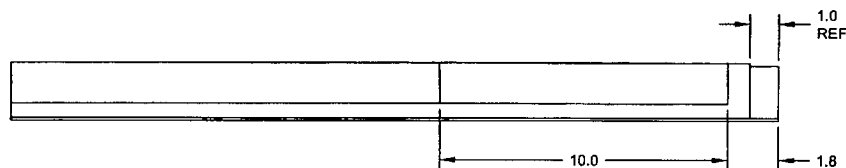
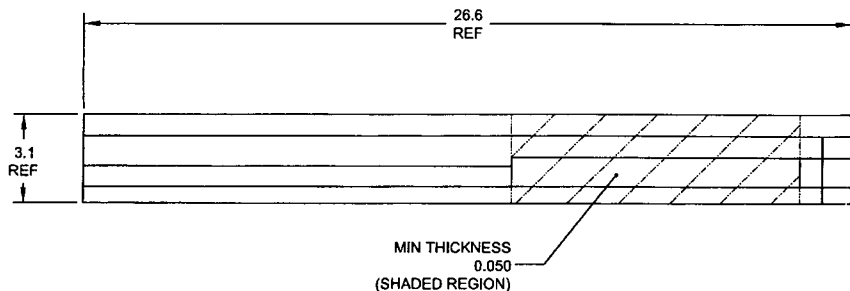
Date: 10/01/14

Prototype Approval: N/A

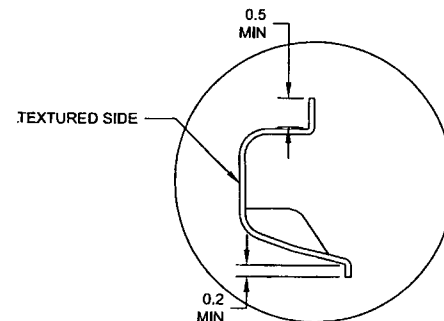
Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>DT</u>

8 7 6 5 4 3 2 1



**D3947-1 PANEL, LH**



*Handwritten:* 1055191

**RELEASED**  
*Handwritten:* 24/05/14

**NOTES:**

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-1" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.42 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9483 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.070" ELSEWHERE

A NEW ISSUE		PH	09.05.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.20		

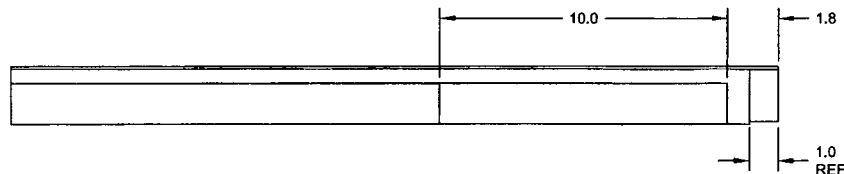
  

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3947	REV. A SHEET 1 OF 4
TITLE PANEL (AS 350/355)	SCALE NTS
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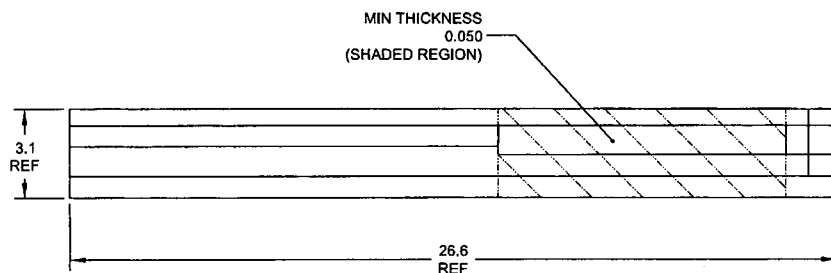
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8 7 6 5 4 3 2 1

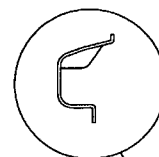
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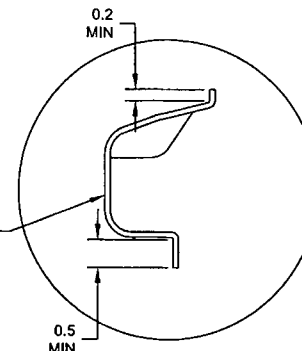
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**D3947-2 PANEL, RH**



**DETAIL B C2-2**



**DETAIL B B3-2**  
SCALE 2X

*WLO 5/5/11*

**RELEASED**  
*09/05/20*

**NOTES:**

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-2" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.42 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9483 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.070" ELSEWHERE

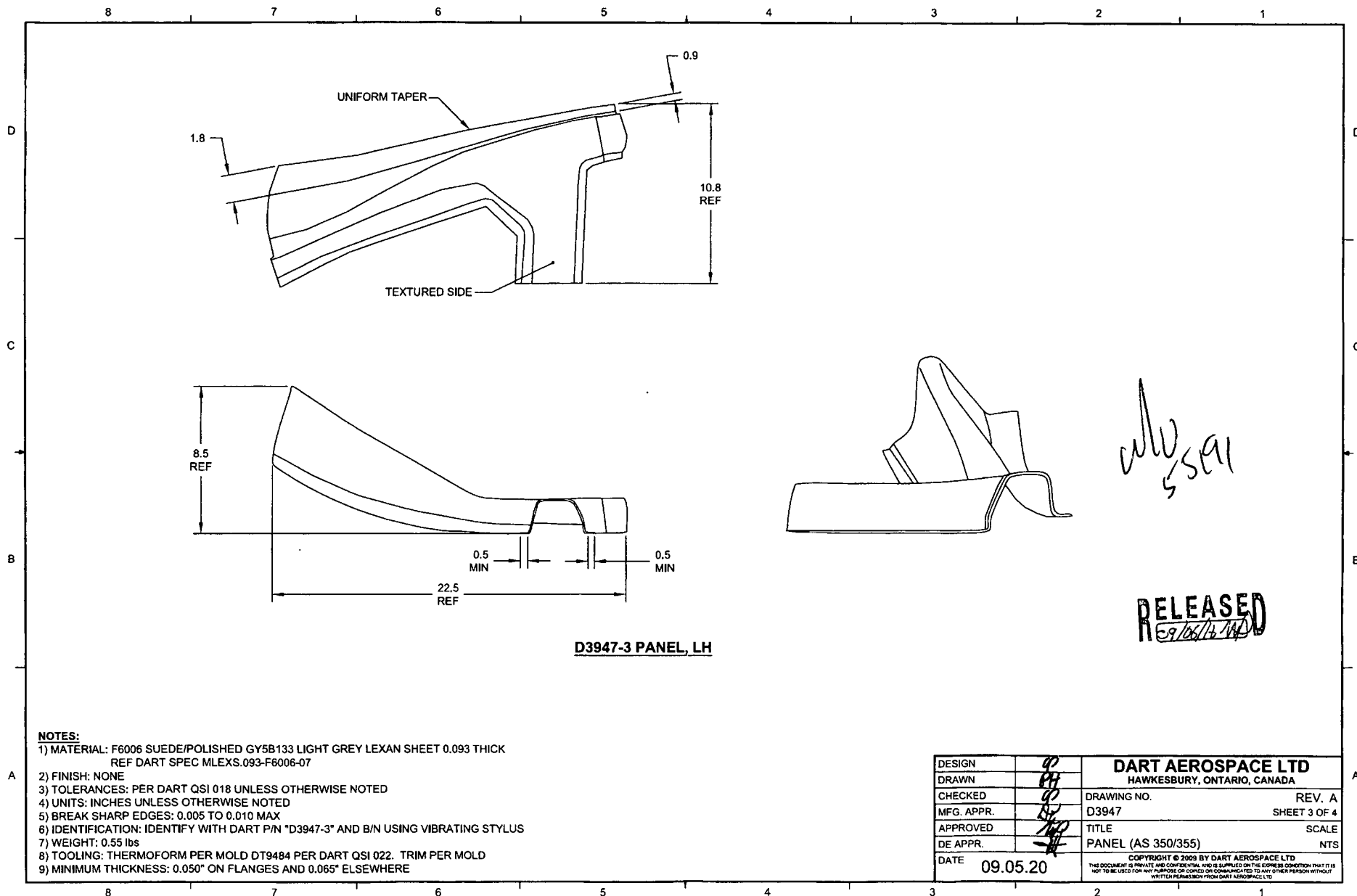
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DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3947	SHEET 2 OF 4
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	PANEL (AS 350/355)	NTS
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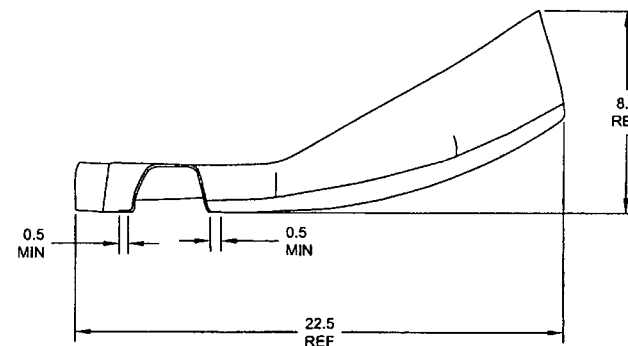
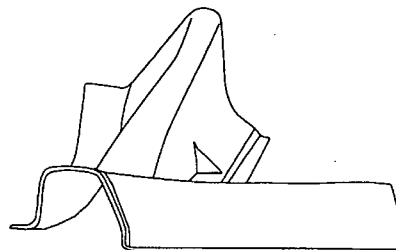
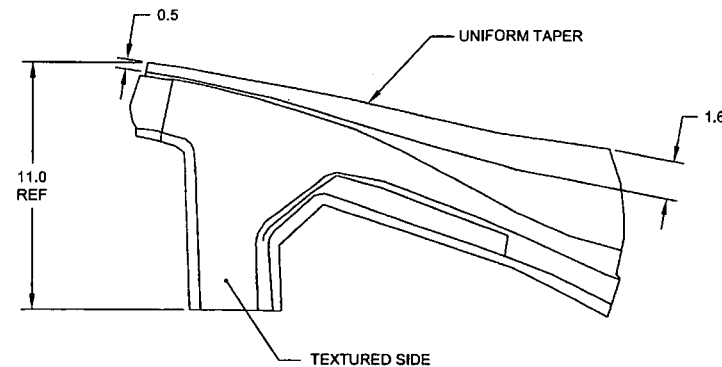
8 7 6 5 4 3 2 1

A

A







*WLB  
5/19/1*

**D3947-4 PANEL, RH**

**RELEASED**  
*09/05/20*

**NOTES:**

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK  
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-4" AND B/N USING VIBRATING STYLUS
- 7) WEIGHT: 0.62 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3947	SHEET 4 OF 4
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